

Date: Thursday, 08/05/2008 12:38:19 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPAD
Job Number :	39133		
Estimate Number :	12785		
P.O. Number :		Part Number :	D356411
This Issue :	08/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3564 REV D
First Issue :	08/05/2008	Project Number :	N/A
Previous Run :	38548	Drawing Revision :	D
		Material :	
Written By :		Due Date :	23/05/2008
Checked & Approved By :	<u>JD 08.05.08</u>	Qty:	20 Um: Each
Comment :	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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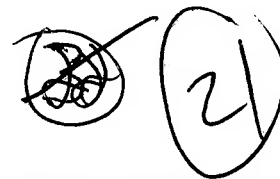


Comment: Qty.: 1.4805 sf(s)/Unit Total : 29.6100 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: 107772 IB 8-5-12

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3564 ***** (D3564-1F) *****
 Dwg Rev: D
 Prog Rev: D IB 8-5-12
 2-Deburr if necessary IB 8-5-12



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

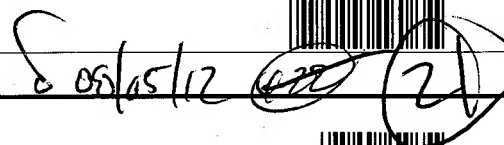


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK



5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3564 using Jigs DT and DT

IB 08/05/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:38:19 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 39133

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 08/05/15 (x21)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

M105959

08-06-05 214

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/06/05 (x29) count

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/05 (x21) count

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 11:30
OVEN TEMPERATURE: 320°
FINISH TIME: 12:00

M105642

FL 08/06/05 (21)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-05 (x21)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: F2-18

HL 08-06-05 (x21)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:38:19 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 39133

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

08/06/06

Job Completion



mf 08-06-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39133
Description: Wearshoe		Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

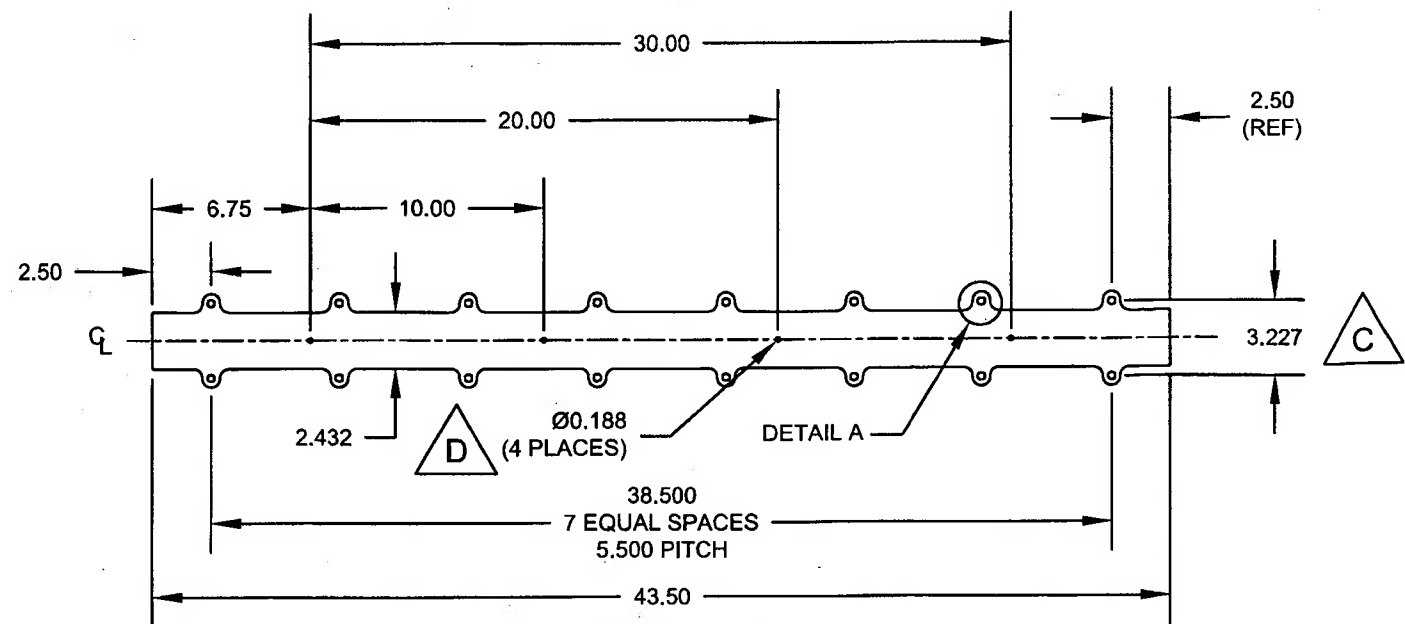
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.226	*			
2.432	+/-0.010	2.434	*			
2.50	+/-0.030	2.50	*			
6.000	+/-0.010	6.000	*			
12.104	+/-0.010	12.100	*			
18.000	+/-0.010	18.000	*			
18.00	+/-0.030	18.00	*			
9.00	+/-0.030	9.00	*			
11.50	+/-0.030	11.50	*			
0.300 x 0.300	+/-0.010	301 x 303	*			
Ø0.188	+0.005/-0.001	Ø0.189	*			
R0.375	+/-0.010	0.375	*			
0.063	+/-0.010	0.059	*			

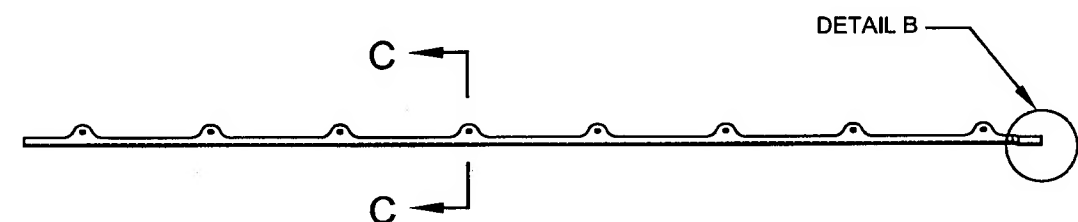
Measured by: IB	Audited by: J	Prototype Approval:	N/A
Date: 8-5-12	Date: 08/05/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	

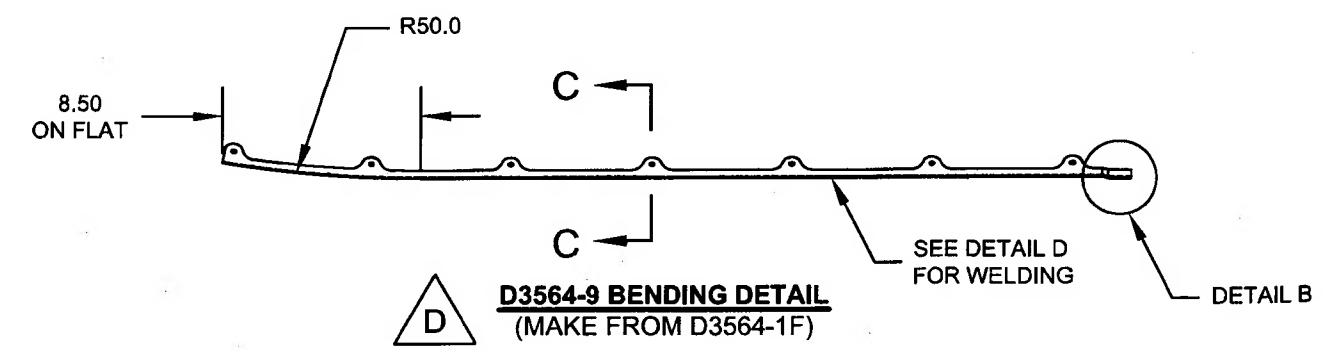
8 7 6 5 4 3 2 1



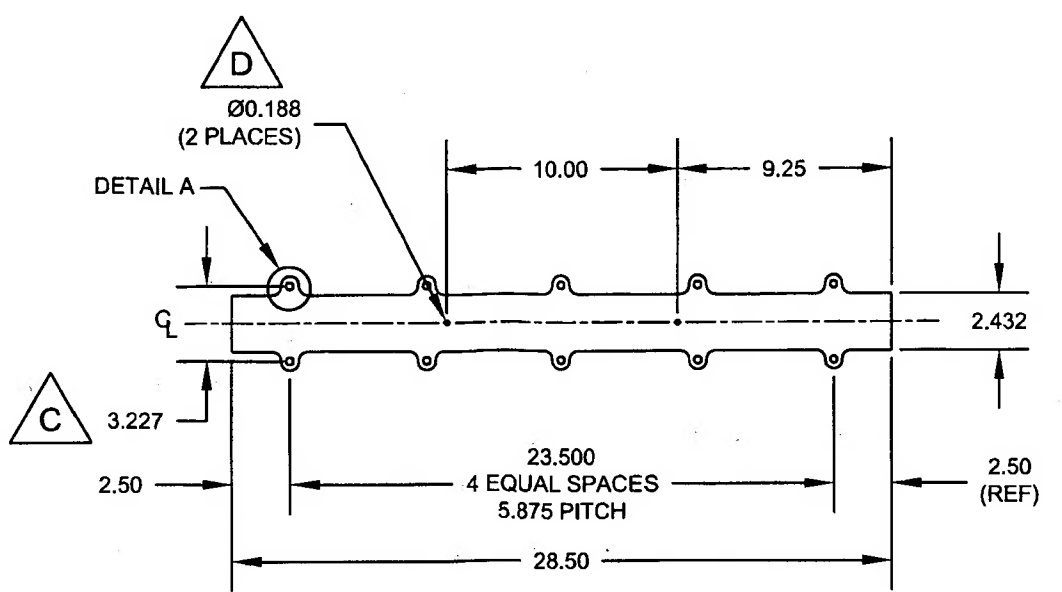
D3564-5F FLAT PATTERN



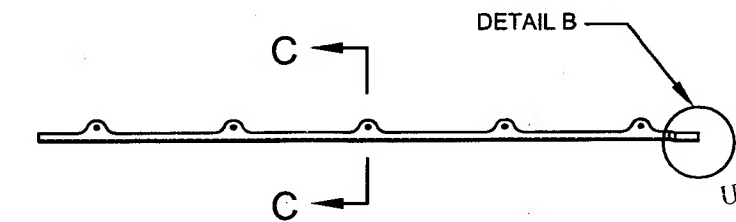
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



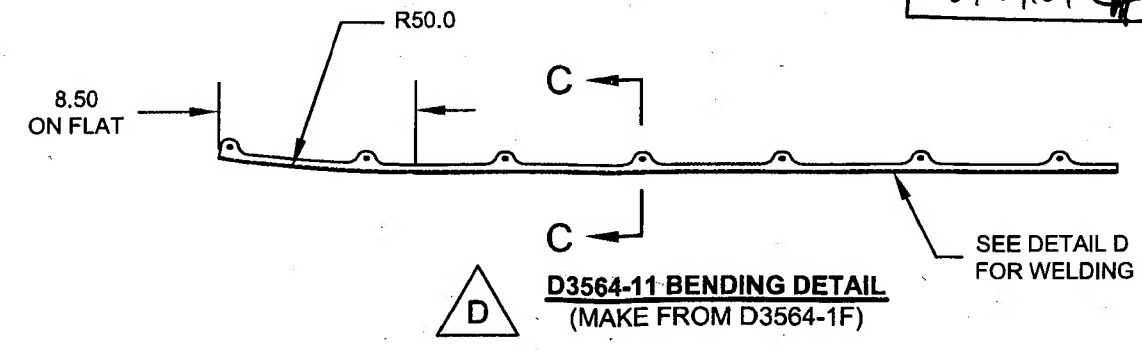
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



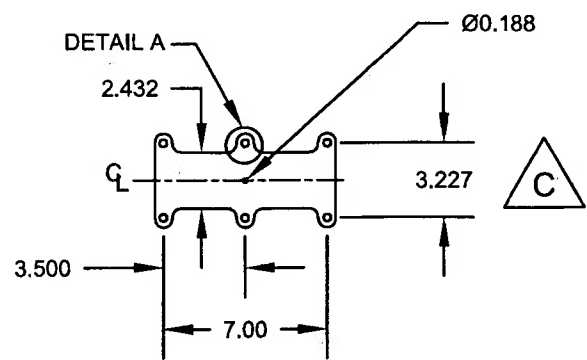
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

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WITHOUT NOTICE
WORK ORDER
NO. 3913

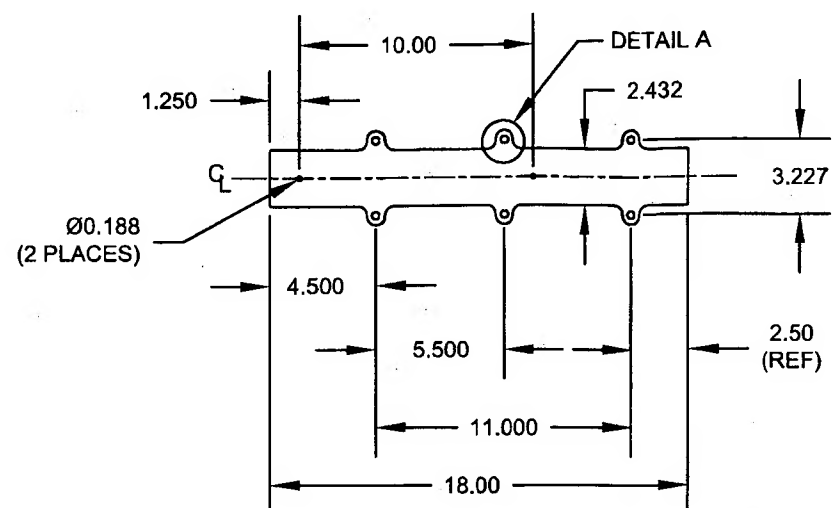
RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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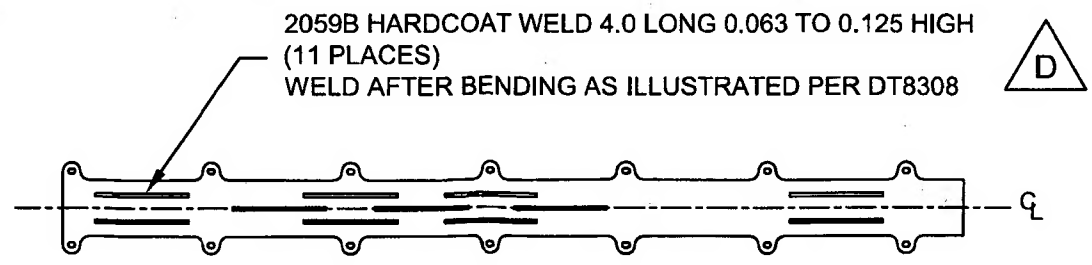
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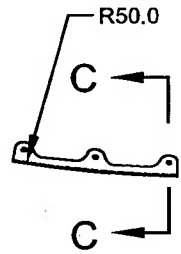
D3564-13F FLAT PATTERN



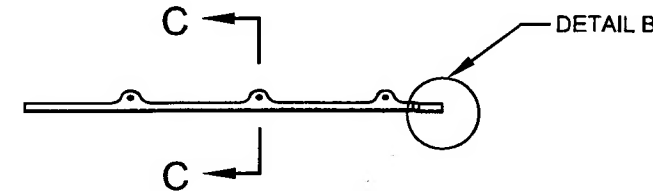
D3564-15F FLAT PATTERN



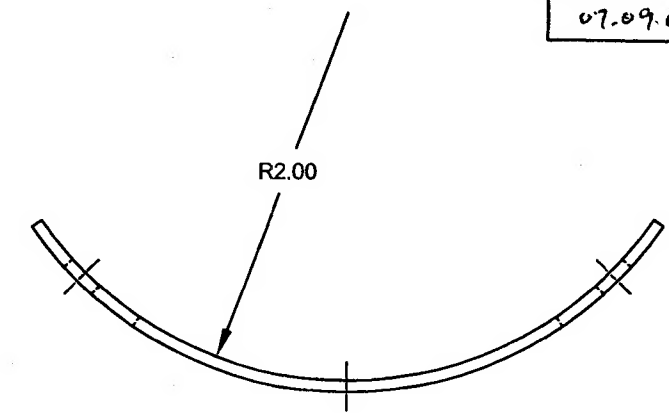
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



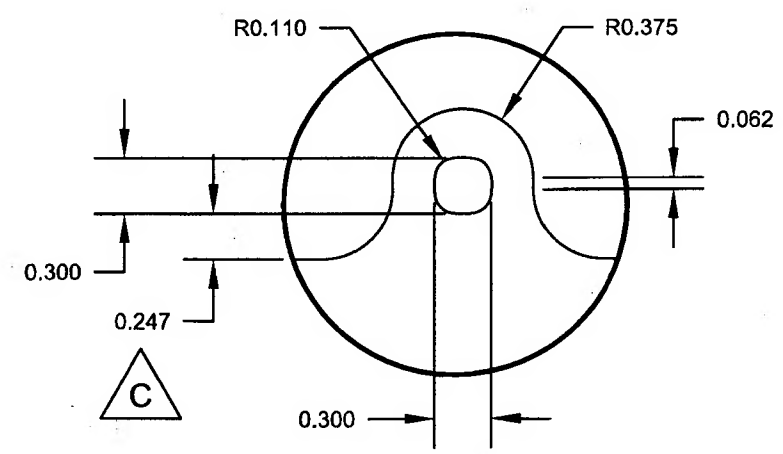
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



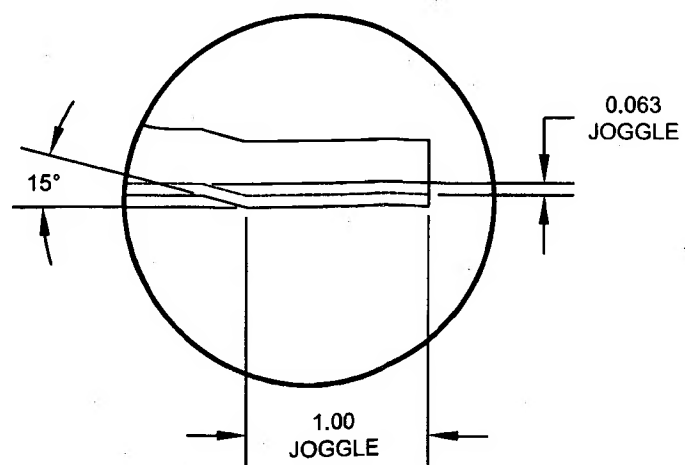
SECTION C-C
SCALE 1:1

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07.09.04

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WORK ORDER
NO. 39130



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
MFG. APPR.	PH	SHEET 3 OF 3	
APPROVED	PH	TITLE WEARSHOE	SCALE 1:8
DE APPR.	PH	DATE 07.08.21	
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